## Work Order ID 52905

October 19, 2009 12:38:27 PM



Page 1

Item ID:

D2574

**Revision ID:** Е

Item Name: Saddle, Aft In 205

**Start Date:** 

10/19/09

Required Date: 11/02/09

**Start Qty: 12.00** Req'd Qty: 12.00



Accept

Cust Item ID:4

**Customer:** 

Reference:

**Approvals:** 

Process Plan: QC: \_\_\_\_\_

Date 10-22 Tooling:

SPC (Y/N): Date:

Date:

Date:

Rev.

Run

Start

Reject

**Qty** 

Stop

Setup Start

Stop

Sequence ID/ **Work Center ID**  Operation Description

**Revision Nbr** 

Set Up/ **Run Hours** 

Draw Number

Plan Draw Code

Accept **Qty** 

Insp. Number Stamp

**Draw Nbr** 

Rev E

D2574

HAAS CNC vertical machine #1

100

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. 5290 Double check by

0.00

1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 13-Machine

Step No 3 per Folio FA051 and insp

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2573 & D2574

ont validate

120

QC2- Inspect parts off machine FAI/FAIB

0.00

ogliolal

Quality Control

Memo

0.00



October 19, 2009 12:38:27 PM

Item ID:

D2574

 $\mathbf{E}$ 

Revision ID: Item Name:

Saddle, Aft In 205

Start Date: Required Date: 11/02/09

10/19/09

**Start Oty: 12.00** 

Rea'd Otv: 12.00



Accept



Setup Start

Stop



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

SPC (Y/N):

0.00

Tooling:

Date:

Stop



Sequence ID/ Work Center ID

130



**Ouality Control** 

Operation Description

OC8- Inspect parts - second check

QC: \_ \_\_\_\_ Date: \_\_\_

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours** 

Draw

0.00 M. A 09/10/26

Number

Draw Rev.

Date:

Plan Code

Reject Accept Otv Oty

Reject Insp. Number Stamp

Run

140



Hand Finishing

Memo

Memo

pl 09-10-27



**Powder Coating** 

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M112760

11:00Am START TIME: 11.3000-UFINISH TIME:

HOVEN TEMPERATURE:

## Work Order ID 52905

October 19, 2009 12:38:27 PM



Page 3

Item ID:

D2574

Revision ID: E

Item Name:

10/19/09

Saddle, Aft In 205

**Start Oty: 12.00** Reg'd Otv: 12.00



Accept



Setup Start



Stop

Reference:

Start Date:

Approvals:

Required Date: 11/02/09

**Process Plan:** 

OC:

Date:

Date:

SPC (Y/N):

**Tooling:** 

Date:

Date:

Draw

Rev.

**Cust Item ID:** 

**Customer:** 

Draw

Number

Plan

Code

Reject

Oty



Sequence ID/ Work Center ID

160

**Quality Control** 

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

Run

Accept

Oty

Start

Stop

Reject Insp.

Number Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Mx 09-10-28

October 19, 2009 12:38:32 PM

Work Order ID: 52905

Parent Item:

D2574RevE

Parent Item Name: Saddle, Aft In 205

Comments:

**Start Date: 10/19/09** 

Required Date: 11/02/09

**Start Qty: 12.00** 

Required Qty: 12.00

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch Bin Primary Item Location

Last Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty Qty To Pick Issued Date Issued

**Status** 

D6101-005RevB

Manufactured

No

110

Each

0.000012.0000

Saddle Billet

646411 × 12 Skap.0/22

UNCONTRO SUBJECT TO WITHC NO.52905 pr/09.10-9 HELEASED R2.0001-0.020 4.124±0.005 1.370±0.005 -R0.57 (TYP) - Ø0.375<sup>+0.005</sup> (TYP 2 PLACES) RIDGE 0.500 0.568 1.179 NOTES ±0.005 - ø0.750 (TYP) R0.75 (TYP) -MATERIAL: 7075-T7351 (QQ-A-250/12) **D** (REF DART SPEC. D6102-003) ACID ETCH, ALODINE PER DART QSI 005 4.1 2.500 Ø0.510 MIN ¢0.257+0.005 ±0.005 FLAT AROUND R0.50 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER 1.179 DART OSI 005 4.3 BREAK ALL SHARP EDGES 0.010 TO 0.020 (TYP 8 PLACES) ALL HOLES R0.50 ±0.005 R0.50 -5.500 R0.063 (TYP) --TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 0.125-1.370±0.005 GRAIN ENGRAVE PART AND BATCH NUMBER IN THIS R0.38 AREA TO MAX DEPTH OF 0.010 DIRECTION (TYP) 0.625  $\bigcirc$  $\bigcirc$ CHAMFER 0.063" x 45" AROUND THIS SURFACE (TYPICAL 2 PLACES) 0.362 0.312\_0.005 /3\ CHAMFER 0.063 x 45° ALL AROUND RIDGE 0.25+0.03 0.125 R0.50 (TYP) CHAMFER 0.033 x 45' (SEE DETAIL C) DETAIL C 0.760+0.005 R0.66 (TYP) 2.050+0.005 VIEW B-B R0.50 3.230±0.020 (TYP) R0.50 (TYP) - 0.750 0.240 FLAT 0.250 -- 0.250 ON RIDGE (TYP ALL RIDGES) R0.50 (TYP) 0.125 R0.50 (TYP) 1.698 RO.188 (TYP AROUND POCKET) (REF) 00.438+0.005 -(TYP 4 PLACES) 0.125 R1.510 0.063 1.750 ±0.005 0.500 3.500±0.005 ±0.005 0.250 0.125 8.000 -SECTION A-A 05.07.13 ADD CHAMFER ON RIDGE NOTE 4 D 02.09.06 ADD RIDGES; TIGHTEN TOLERANCES INCORP. DEO 9123/9079/9102 С 99.10.22 ADD DIMENSIONS PER TSR A1177 R0.025 8 ADD GRAIN DIR., 0.438 WAS 0.425 (REF. TYP) 96.12.02 96.09,16 NEW ISSUE OFSIGN DART AEROSPACE LTD. DART COPYRIGHT @ 2008 BY DART AEROSPACE LTD. DS PH DETAIL CHECKED ROVED THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. SCALE 2:1 D2574 SHEET : OF (TYP) DATE SCALE INNER AFT SADDLE 05.07.13 2:3

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DART AEROSPACE LTD	Work Order:	52905
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443		.441	.440	,439	,440		
В	1.745	1.755		1.750	1.750	1.749	1.749		0
С	3.495	3.505		3-500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.750	1.749	1.749		-
Е	7.990	8.010		3.000	8.002	8.002	8.002		
F	0.490	0.510		. 497	. 509	.504	.504		
G	0.257	0.262		-259	5	.259	,259		·—·—
Н	0.375	0.380		. 377	.377	.377	-372		
1	0.490	0.510		.502	-501	502	.501		
J	1.174	1.184		1.130	1.178	1.177	1.177		
K	0.558	0.578		.574	.5/2	.569	.569		
L	1.174	1.184		1.130	1.178	1.177	1.177		
М	1.365	1.375		1. 370	1.369	1.369	1.369		
N	2.495	2.505		2500	2.499	2.499	2,499	1	
0	4.119	4.129		4.124	4.122	4.123	4.123		
Р	0.115	0.135		.127	126	.126	126		
Q	0.115	0.135		.135	135	.135	./35		
R	0.240	0.260		.253	1.250	.257	,250		
S	0.115	0.135		-125	7.53	./35	134		
Т	0.178	0.198		138	:188	. 120	.134		
U	3.210	3.250		3,23/	3.229	.188 3.230	3.230		
V	0.230	0.250		.234	-230	-240	.237		
W	0.115	0.135		.124	.129	.128	126		
Х	0.307	0.312		.3/1	.3/2	311	.3//		
Υ	0.760	0.765		760	.760	.740	-760		
Z	0.352	0.372		.367	-361	.365	.365		
AA	0.470	0.530		<5°€∞	570	.500	500		
AB	0.615	0.635	······································	624	.630	.628	.629		
AC	0.053	0.073	-	- 063	.063	.063	-063		
AD	0.240	0.260		.250	240	.249	-246		
ΑE	1.500	1.520		1.510	1.577	1.570	1.570	<i>i</i>	
AF	0.115	0.135		./35	./35	.135	135		
AG	0.240	0.280	<del></del>	. 260	.275	.273	275		
AH	0.240	0.260		.247	.242	250	.249		
Al	2.000	2.020		2.004	2.008	2.000	2.001		
ĀJ	0.023	0.043	<del></del>	.033	.033	033	.033		
		ept/Reje	ot						

Measured by:	Audited by	A.A	
Date: 69/10/23	Date:	09/10/26	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	- 1
E	05.12.05	Added dimension AJ	KJ/JLM 🚓	911

DART AEROSPACE LTD	Work Order:	52905
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Re	Recorded Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	15	26	3/7	48	Ву	Date
Α	0.438	0.443		.440	,439	.440	.440		
В	1.745	1.755		1.750	1.749	1.750_	1.749		
С	3.495	3.505		3,500	3,499	3.500	3.499		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.50 Ce_	.505	.505	.502		
G	0.257	0.262		251	1,259	377	.377		
Н	0.375	0.380		.377	377	377	.377		
l	0.490	0.510		.500	-501	- 501	.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.568	.57,9	.569	.570		
L	1.174	1.184		1.177	1.177	1.177	1.177		
М	1.365	1.375		1.368	1.368	1.369	1.369		
N	2.495	2.505		2.499	2.499	2,499	2.499		
0	4.119	4.129		4.122	4.122	4.122	4.123		
Р	0.115	0.135		.124	.123	:124	.124		
Q	0.115	0.135		. 135	.135	.135	. 135		
R	0.240	0.260		.249	.250	.257	. 257		
S	0.115	0.135		.737	.131	.132	.131		
Т	0.178	0.198		. 188	. 188	.188	. 188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250	-	.23%	.236	-236	. 237		
W	0.115	0.135		.128	.129	. 129	. 128		
Х	0.307	0.312		13/2	.312	.312	,3/2		
Υ	0.760	0.765	***	.760	760	.760	.760		
Z	0.352	0.372		1364	-363	.364	.362		
AA	0.470	0.530	-	.500	.500	,500	-500		
AB	0.615	0.635		-428	.627	.629	.628		
AC	0.053	0.073		.063	-063	.063	.063		
AD	0.240	0.260		243	-244	1.244	.244		
ΑE	1.500	1.520		1.512	1.512	1.572	1.572		
AF	0.115	0.135		.135	. /35	.135	. /3'5		
AG	0.240	0.280		.270	.271	.274	.275		
АН	0.240	0.260		-246	.241	-246	.247		
Al	2.000	2.020	_	2.003	2.004	2.005	2.603		
AJ	0.023	0.043		.033	.033	-033	.033		
	Acc	ept/Reje	ct						

Measured by:	Audited by H.A
Date: 09/10/25	Date: 09/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1
E	05.12.05	Added dimension AJ	KJ/JLM A	411

DART AEROSPACE LTD	Work Order:	52905
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	200	\$11.	#12	Ву	Date \
Α	0.438	0.443		. 439	.439	.440	.440		
В	1.745	1.755		1.749	1.749	1.750	1.749		
С	3.495	3.505		3.506	3,499	3.500	3,500		
D	1.745	1.755		1.749	1.749	1.750	1.749		
E	7.990	8.010		8.000	8.002	8.002	8.002		
F	0.490	0.510		508	,507	.504	.504		
G	0.257	0.262		.259	.259	,259	260		
Н	0.375	0.380		1.377	.377	.377	.377		
1	0.490	0.510		.502	1502	.501	.502		
J	1.174	1.184		1.177	1.177	1.178	1,178		
K	0.558	0.578		.569	-5709	.568	.569		
L	1.174	1.184		1.177	1.177	1.177	1.178		
М	1.365	1.375		1.368	1.369	1.369	1.370		
Ν	2.495	2.505		2.499	2,499	2.499	2.499		
0	4.119	4.129		4.122	4.122	4.123	4.124		
Р	0.115	0.135		-126	.126	,128	1.126		
Q	0.115	0.135		./35	135	./35	,/35		
R	0.240	0.260		,257	.250	.253	-257		
S	0.115	0.135		133	./33	134	.132		
Τ	0.178	0.198		. 188	. 188	1.228	. 188		
U	3.210	3.250		3,228	3.228	3.228	3,229		
V	0.230	0.250		1,238	.237	.237	.236		
W	0.115	0.135		126	.126	.125	127		
Х	0.307	0.312		.312	,312	.311	.3/2		
Υ	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		361	.362	361	362		·
AA	0.470	0.530		,500	,500	.500	.500		
AB	0.615	0.635		-626	.629	-629	-42t		
AC	0.053	0.073		.063	-063	.063	.063		
AD	0.240	0.260	<u></u>	.245		.243	.243		
AE	1.500	1.520		1.572	1.512	1.575	1,573		
AF	0.115	0.135		135	./35	-/35	-135		
AG	0.240	0.280		.270	1.271	.271	.271		
AH	0.240	0.260		1.248	.247	.245	246		
ΑÍ	2.000	2.020		2.003	2,003	2.006	2,005		
AJ	0.023	0.043		. 033	.033	-033	. ৩33		
	Acc	ept/Reje	ct				<u> </u>		

Measured by:	46	Audited by H.A	
Date:	09/10/26	Date: 09/10/26	
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Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.27	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-1
E	05.12.05	Added dimension AJ	KJ/JLM A	